

Date: Tuesday, 7/18/2006 3:01:14 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BRACKET
<b>Job Number</b> :	27976		
<b>Estimate Number</b> :	12450		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D351613
<b>This Issue</b> :	7/18/2006	<b>S.O. No.</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	PRELIMINARY
<b>First Issue</b> :	7/18/2006	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	27659	<b>Drawing Revision</b> :	N/A
	<b>Type</b> :	<b>Material</b> :	N/A
	SMALL / MED FAB	<b>Due Date</b> :	7/25/2006
<b>Written By</b> :	<i>See comment below</i>		<b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	<i>06-07-19</i>		
<b>Comment</b> :			

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S11GA	304/316 .125 Sheet
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**Comment:** Qty.: 0.0236 sf(s)/Unit Total : 0.2360 sf(s)  
 304/316 .125 Sheet 11GA  
 (M304S11GA)  
 Batch: *110/463*

*06 07 21*

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3516  
 Dwg Rev: *A*  
 Prog Rev: *A*  
 2-Deburr if necessary

*06 07 21* *m.f. 06/07/24* *(10)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*06 07 21* *(10)*

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

*06 07 24* *(10)*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
 Form as per Dwg D3516

*(10)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/08/04	SO	Parts can not meet bend dimensions. flat pattern is .200 too long.	CP 06.08.04 per QS/472	Eng. to revise and resize flat pattern. Scrap & destroy	SAD 06.08.04	[Signature] 06.08.04	CP 06.08.04 per QS/472	[Signature] 06.08.04

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/08/04

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Tuesday, 7/18/2006 3:01:15 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 27976

Part Number: D351613

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

ALL SCRAP.

06/08/09

Job Completion



U 06-08-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

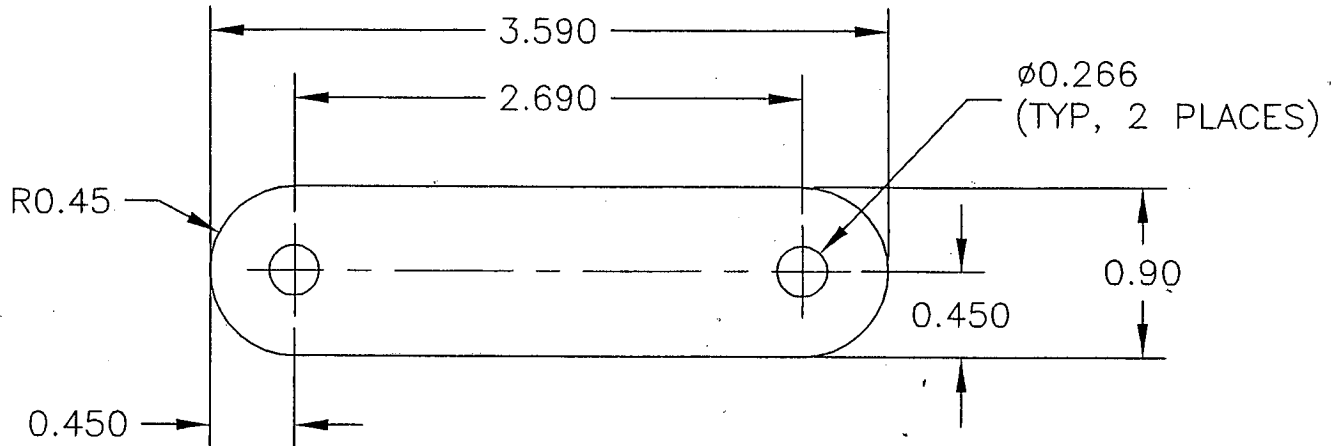
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

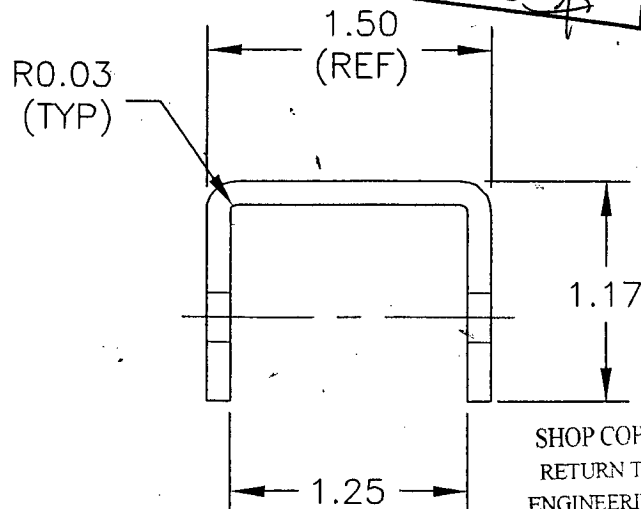
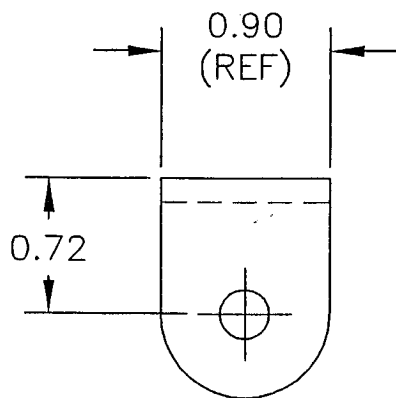
**PRELIMINARY ISSUE**

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3516	REV. A SHEET 5 OF 5
DATE 06.07.14		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:1



**D3516-13F CLEVIS FLAT PATTERN**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)  
(REF. DART SPEC. M304S11GA)



**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
06.07.10 *B*

**D3516-13 CLEVIS BENDING DETAIL**

- 1) MATERIAL: MAKE FROM D3516-13F  
2) ALL DIMENSIONS ARE IN INCHES  
3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *27976*

